

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 1

Item ID: D3849-043

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: MF

QC:

Date: 09-09-22 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3849

B

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3849

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

0.00

0.00

Cust Item ID:

Customer:

SCRAP
Now 2
Re-D

IB 9-9-30

IB 9-9-30

EL 12-10-16

(P10) →

(7)

~~Split 3~~ Split 4

2014

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 2

Item ID: D3849-043
 Revision ID: B
 Item Name: AFT WEARPLATE ASSY, STD GEAR
 Start Date: 09/23/2009 Start Qty: 2.00
 Required Date: 10/02/2009 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

120

 QC
 Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

27 Serial 101

(47)

4

130

 Brake NC
 Brake NC

Memo

Form as per dwg using DT8179 & DT8155

0.00

0.00

09/00/05

7

0

140

 QC
 Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 Serial 102

(47)

1

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 3

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

Memo

0.00

0.00

1- On D3901 bar, fill cut outs with hardcoat welding rod as per dwg D3849
2059 B Hardcoat Welding Rod
BATCH#: _____

2- Weld D3901 bar to wearplate by positioning holes together as per dwg
D3849
304 S.S. Welding Rod
BATCH #: _____

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Work Order ID 52402

September 22, 2009 11:33:06 AM

Page 4

Item ID: D3849-043

Accept

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 5

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Small Fab

Memo

0.00

0.00

I- Bond D3848 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg D3849
BATCH: _____

210



QC

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

220



Packaging

Memo

Identify as per dwg & Stock Location: _____

0.00

0.00

Packaging

Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 6

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Stop



Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W1210.16

Picklist Print

Page 1

September 22, 2009 11:33:05 AM

Work Order ID: 52402

Parent Item: D3849-043RevB

Parent Item Name: AFT WEARPLATE ASSY, STD GEAR

Comments:

Start Date: 09/23/2009

Required Date: 10/02/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3848-3RevB		Manufactured	No				Each	0.0000	2.0000			
Gasket												
D3901-3RevB		Manufactured	No				Each	0.0000	2.0000			
Bar												
M304S18GA		Purchased	No				sf	183.4395	6.4211			
304/316 .050 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

108156

111743

112178

183.4395053

0.98526316

23.7174

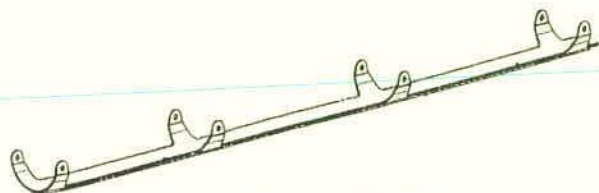
158.736842

20 09/12/17

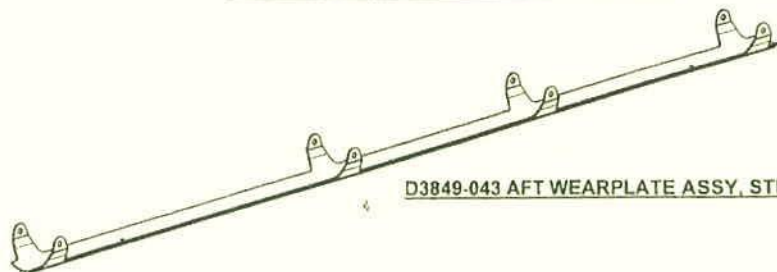
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139-4-30

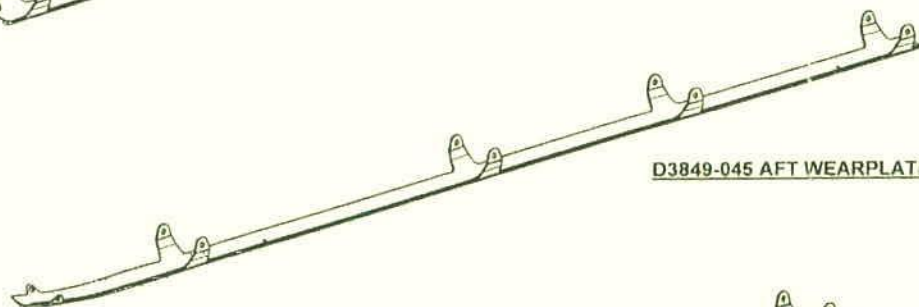
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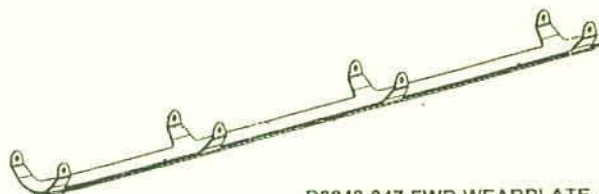
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



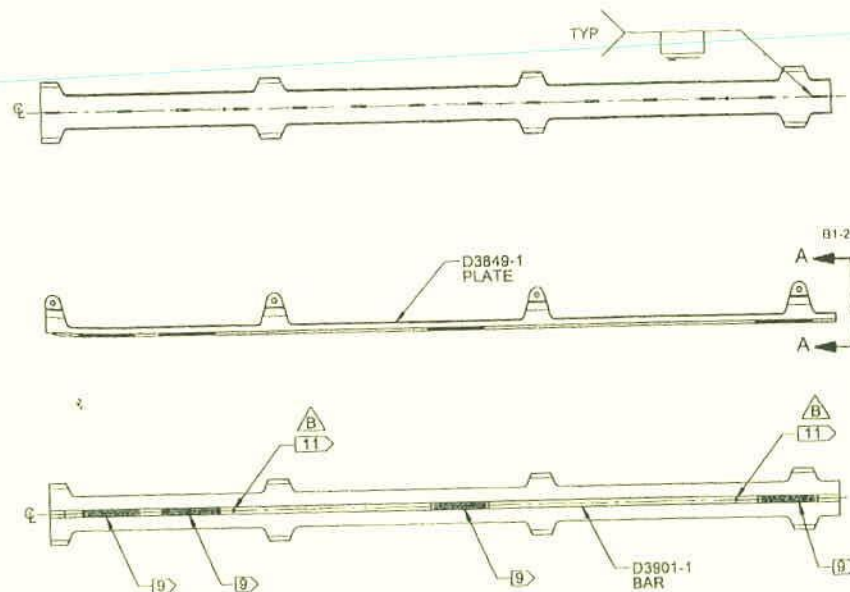
D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

#52403

RELEASED
08/07/15

B		REVISED FLAT PATTERN (0.375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5 B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7P (ZN C4-8, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.4 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66 87 WAS 67.38 (ZN 14-7)		RF	09.06.30
A		NEW ISSUE		RF	09.03.30
REV		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		REV. B	
DRAWN	RF	PORT HADLOCK, WA		SHEET 1 OF 10	
CHECKED	RF	DRAWING NO. D3849		SCALE NTS	
MFG. APPR.	RF	TITLE WEARPLATE ASSY		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
APPROVED	RF	DATE 09.06.30		THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPIRY DATE 09-06-30. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER REASON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



D3849-041 FWD WEARPLATE ASSY. STD/FLOAT GEAR B



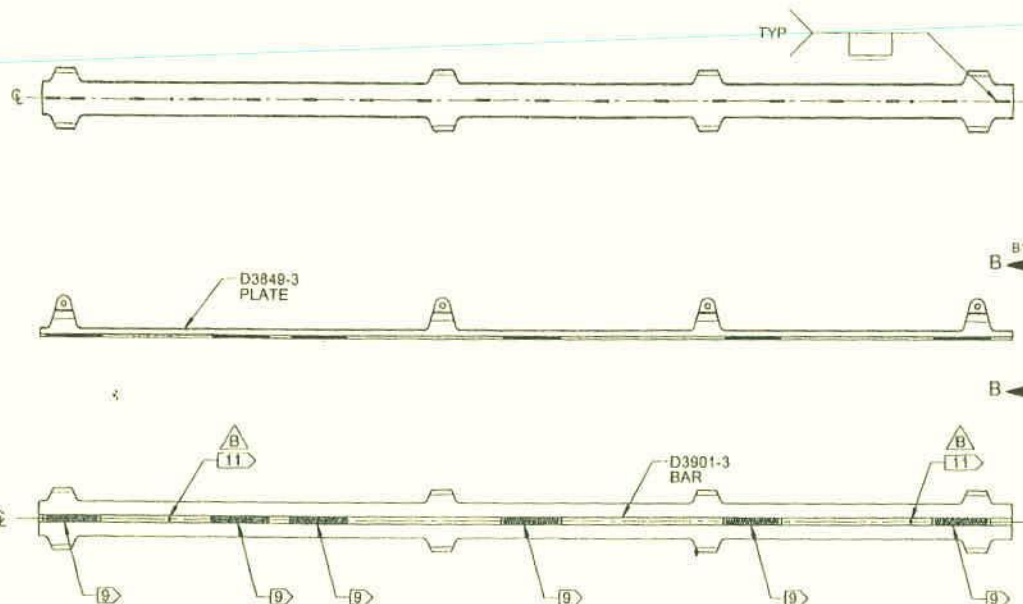
SECTION A-A C32
SCALE 2X

RELEASED
09/27/12

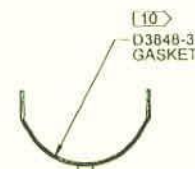
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2058B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

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MFG. APPR.	RF	D3849	SHEET 2 OF 10
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DE APPR.	RF	WEARPLATE ASSY	NTS
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#58402



SECTION B-B C2-3
SCALE 2X

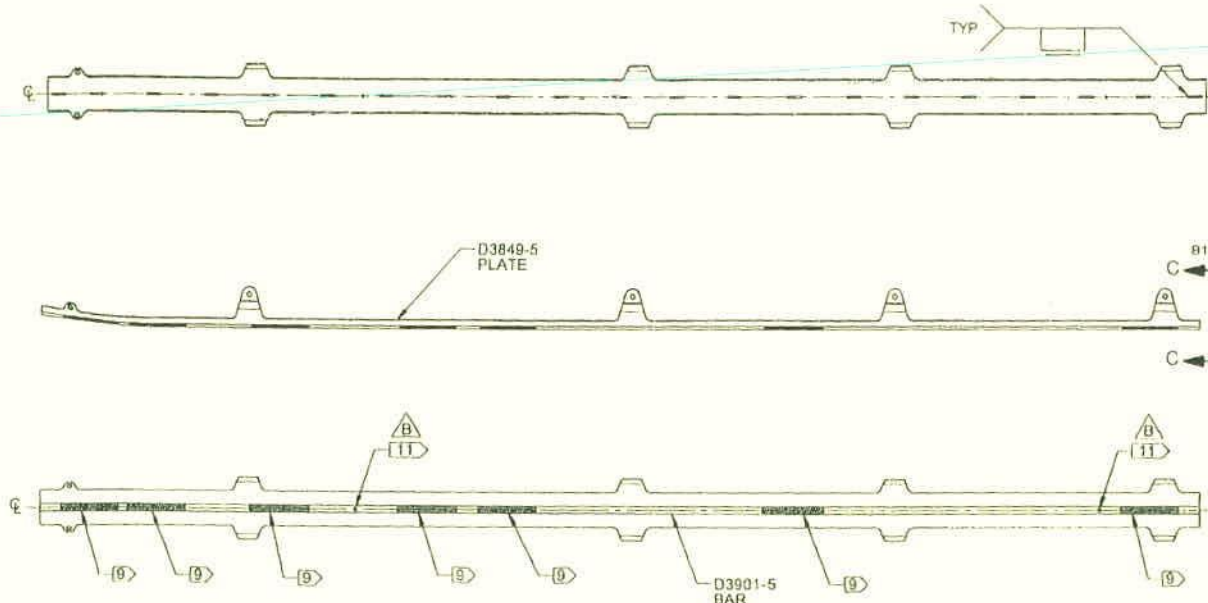
D3849-043 AFT WEARPLATE ASSY, STD GEAR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3848-3 PLATE TO D3901-3 BAR

RELEASED
2/27/15

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	SHEET 3 OF 10	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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#52408

D3849-045 AFT WEARPLATE ASSY. FLOAT GEAR

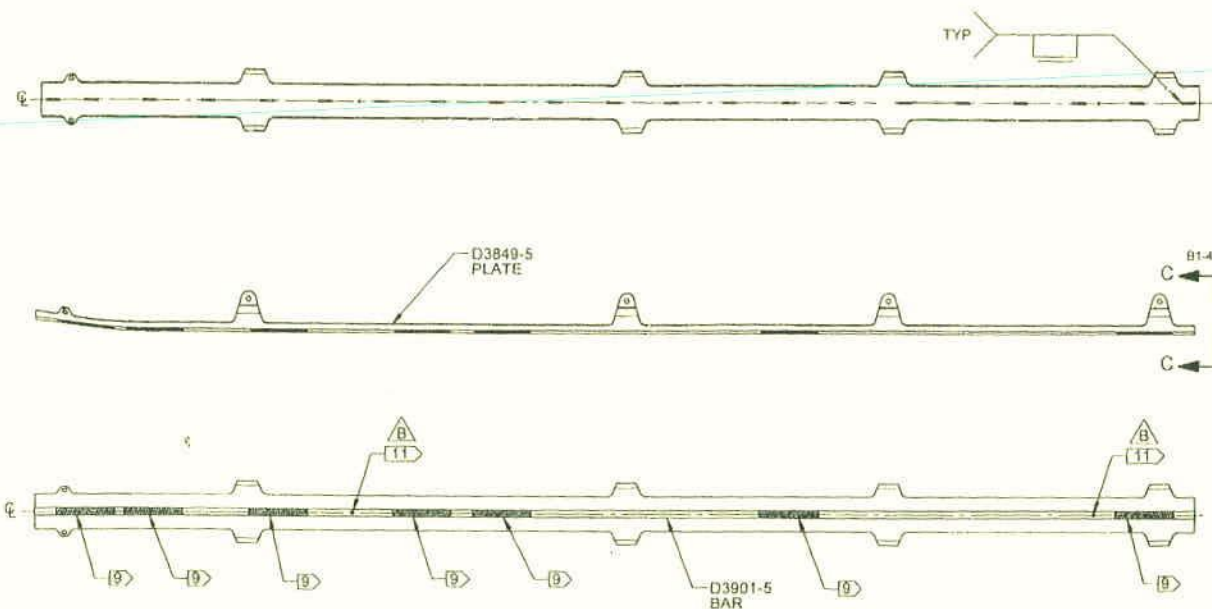
SECTION C-C C2-4
SCALE 2X

RELEASED
09/06/30

NOTES:

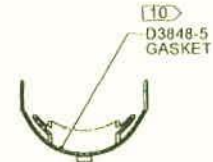
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 6.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3849-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL ϕ 0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 4 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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#52407

D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



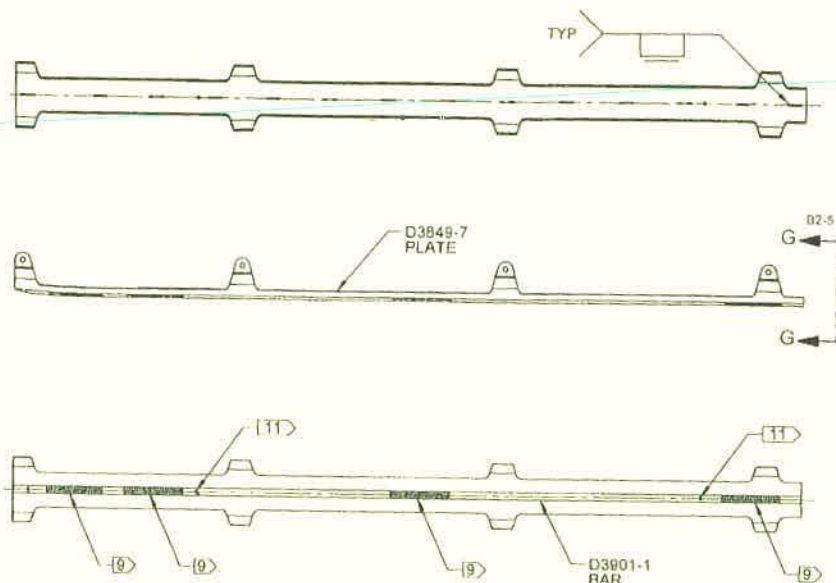
SECTION C-C C2-4
SCALE 2X

RELEASED
10/15/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3848-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 4 OF 10
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DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR ⚠



SECTION G-G C3-5
SCALE 2X

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION; IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3801-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-7 PLATE TO D3801-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 5 OF 10
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RELEASED
09/07/15 MFB

#52402

0.3 REF

R38.5

49.51

A6-10

D3849-1 PLATE
(MAKE FROM D3849-1F)

#50402

0.050
REF

7.72

51.313

38.000

DETAIL G

C2-10

R0.38
TYP

DETAIL F

A3-10

18.000

DETAIL H

C3-10

2.45

2.433
TYP6.642
4 PLR0.06
2 PLØ0.188 THRU
2 PL105°
TYPR0.50
TYP4.00
TYP

4.38

7.00

54.26 REF

D3849-1F FLAT PATTERN

RELEASED
01/07/15/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

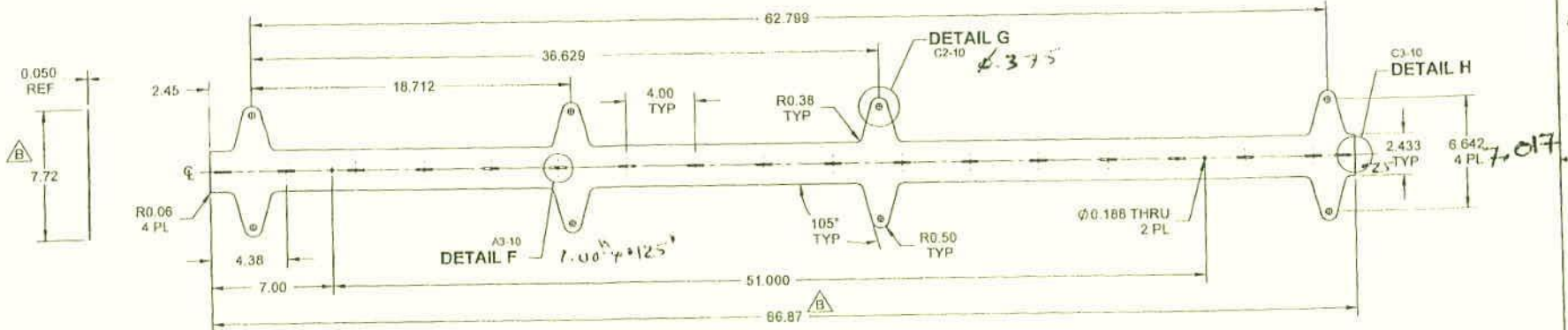
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 6 OF 10
APPROVED	RF	TITLE	SCALE
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8 7 6 5 4 3 2 1



D3849-3 PLATE
(MAKE FROM D3849-3F)

#50403



D3849-3F FLAT PATTERN

RELEASED
11/07/05

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

0.3 REF

R38.5

49.51

CS-10

D3849-7 PLATE 
(MAKE FROM D3849-7F)

153402

0.050
REF

7.88

51.313

C2-10
DETAIL G

5.89

R0.38
TYP

36.000

A3-10
DETAIL F

18.000

C3-10
DETAIL H

2.45

2.433
TYP6.801
4 PLØ0.188 THRU
2 PL105°
TYPR0.50
TYP4.00
TYP


4.38

R0.06
2 PL

34.500

7.00

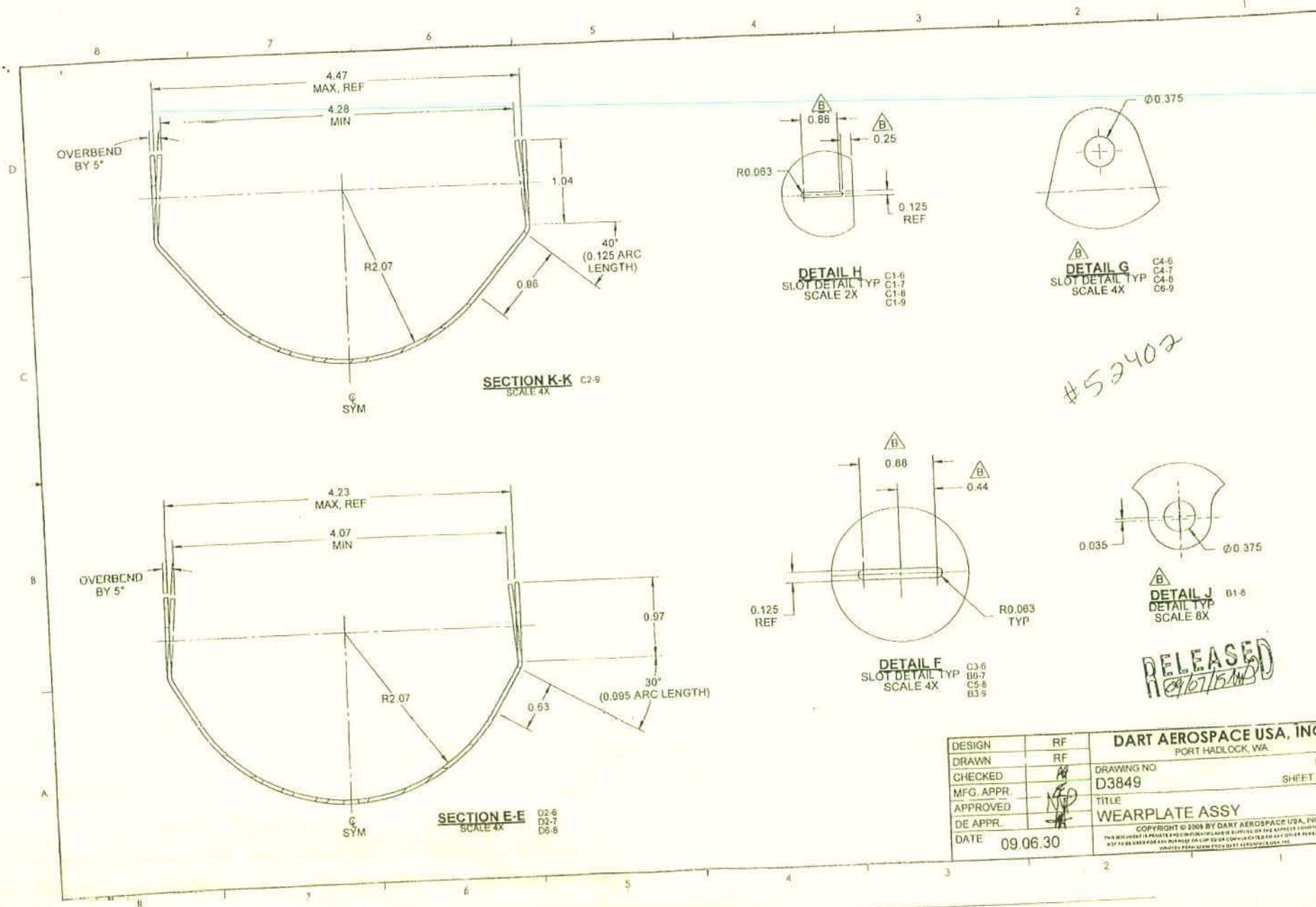
54.26

D3849-7F FLAT PATTERN 

RELEASED
2/6/7/12

- NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	AF	DRAWING NO.	REV. B
MFG. APPR.	CF	D3849	SHEET 9 OF 10
APPROVED	AF	TITLE	SCALE
DE APPR.	AF	WEARPLATE ASSY	NTS
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CHECKED	RF	DRAWING NO	REV B
MFG. APPR	RF	D3849	SHEET 10 OF 10
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